

Work Order ID 121890

Thursday, July 03, 2014 1:32:30 PM

121890

Page 1

Item ID: D3965-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearing, Spherical
Start Date: 7/4/2014 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 7/4/2014 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: CL Date: 14/07/03 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3965	B								

100

0.00

100

Purchasing

Purchasing

Memo

PURCHASING

Issue P/O: 24857

Purchase Part Number: 63215K31

Possible Supplier: McMaster

Material release note is required

0.00

CL 14/07/03 10

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

14/7/4 10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00 S M H / 4				10			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00				10X		DAS 28 9-89	JUL 07 2014
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

MLJ 14-07-08
①4-7-7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

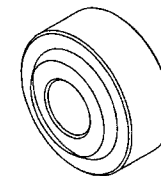
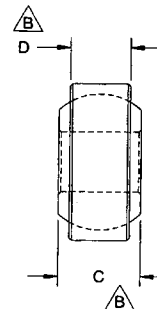
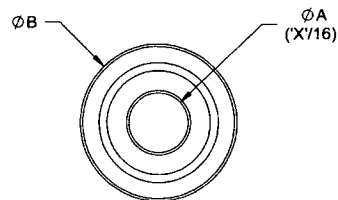
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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SPECIFICATION CONTROL DRAWING



CL14107/03
W10: 121890

D3965-X BEARING, SPHERICAL
WHERE 'X' IS I.D. IN 1/16" OF AN INCH
EG Ø 1/4" (4/16") I.D. BEARING = D3965-4

DART P/N	SUPPLIER	SUPPLIER P/N	A	B	C	D	STATIC RADIAL LOAD CAP. lbs
D3965-3	McMASTER-CARR	63215K31	0.188	0.563	0.281	.219	3,975
D3965-4	McMASTER-CARR	63215K52	0.250	0.656	0.344	0.250	6,040
D3965-5	McMASTER-CARR	63215K53	0.313	0.750	0.375	0.281	8,750
D3965-6	McMASTER-CARR	63215K34	0.375	0.813	0.406	0.313	10,540

RELEASED
2012-03-02

- NOTES:
1) MATERIAL: 440C STAINLESS STEEL WITH PTFE LINER
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

B	CORRECT LETTER DESIGNATED C & D (ZN C4-1) PER PART 11-151	RF	12.01.10
A	NEW ISSUE	RF	09.07.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	160	DRAWING NO.	REV. B
MFG. APPR.	EE	D3965	SHEET 1 OF 1
APPROVED	160	TITLE	SCALE
DE APPR.	160	BEARING, SPHERICAL	NTS
DATE	12.01.10	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24862**

Purchase Order Date 7/3/2014

PO Print Date 7/3/2014

Page Number 2 of 2

Order From :

VU-MCM001

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 330 995 5500

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Line Total: \$150.48

Deliver To: CHANTAL

4	71500-65	2340A12 0-8 CALIPER MITUTOYO	7/7/2014	2.00	\$232.56	\$465.12
			Yes	Each		
			7/7/2014			

Line Total: \$465.12

Deliver To: ERLD

5	63215K31	Spherical Bearing	7/7/2014	10.00	\$15.92	\$159.20
			Yes	Each		
			7/7/2014			

AS PER DWG D 3965 REV. B
B121890

Line Total: \$159.20

PO Total: \$929.05

PO Instructions: PROCUREMENT QUALITY CLAUSES
A000 QUALITY CLAUSES NOT REQUIRED

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 2

Change Date: 7/3/2014



Purchase Order
PO24862

Page 1 of 1

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
le.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Order Placed By
Chantal Lavoie

07/03/2014

McMaster-Carr Number
5927247-01

LNS A12

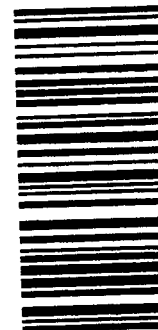
Line	Description	Ordered	Shipped			
1	5917A6 Black Rubber Hammer, Hardwood Handle, 2-1/8 lb Overall Weight, 2-1/2" Face Diameter Your Part Number: 71500-65	1 Each	1	1 - 515 - 04	01 - 39 A6	1 EA 1
2	46325A92 Holder for 2" Diameter Quick Change Sanding Disc Your Part Number: 71500-10	12 Each	12	1 - 72		2
3	46325A93 Holder for 3" Diameter Quick Change Sanding Disc Your Part Number: 71500-15	12 Each	12	1 - 71		3
4	2340A12 Mitutoyo Harsh Environment Electronic Caliper, Number 500-753-10, 0-8" (0-200MM) Range Your Part Number: 71500-65	2 Each	2	1 - 126		4 HZ-N
5	63215K31 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/16" ID, 9/16" OD, 9/32" Ball Thick Your Part Number: .	10 Each	10	3 - 482		5

M/7/14
SHB

Dart Aerospace Ltd

EXP
INV

Sm
18x8x6



8 lbs
5 lines

FW1WBP14
07/03/2014
12:46/12:57
546
Cycle 43

1141177767882

